

Work Order ID 86984

86984

Page 1

Friday, July 06, 2012 12:50:08 PM

Item ID: D412-630-032 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Pilot/Co-Pilot Step, RH (Folding)
 Start Date: 7/6/2012 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 7/18/2012 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: 14 Date: 12-07-16 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
IIN D412-630	Rev M

100 ***100*** DOCUMENT CONTROL 0.00
 DC Memo 0.00
 Document Control Photocopy D412-630 bluefile & type labels per PPP412-630-032 CHG003

110 ***110*** Small Fab 0.00
 Small Fab Memo 0.00
 Small Fab Assemble as per IIN D412-630
 ****ensure tension to retract step is 11 to 18 lbs before installing lockwire.****
 A/R MS20995C41 batch: 1114830

120 ***120*** QC5- Inspect part completeness to step on W/O 0.00
 QC Memo 0.00
 Quality Control ****ensure tension to retract step is 11 to 18 lbs ****
 Test fit on aircraft in Eng. lab.

12-10-9
(2)

12/10/11

2

Smb
12.10.12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86984***86984***

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Friday, July 06, 2012 12:50:08 PM

Item ID: D412-630-032

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/18/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Pick Kit	0.00							
130									
Packaging	Memo	0.00				2x			SP 12-10-4
Packaging									
140	QC4- 100% Inspect kits for completeness	0.00							
140									
QC	Memo	0.00				(+2)			
Quality Control						RM			
150		0.00							
150									
Packaging	Packaging								
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D412-630-032								
	Location: 0000 128								
	PPP Rev: _____ Change All								

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Revision ID: Stop ***NS2***
Item Name: Pilot/Co-Pilot Step, RH (Folding)
Start Date: 7/6/2012 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/18/2012 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

12/10/22 *[Signature]*

12-10-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Work Order ID: 86984

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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV. A 05.11.21 NEW ISSUE EC
IPP REV. B 05.12.19 updated pick list EC
IPP REV. C 07.11.12 ecn 1019, nochg EC verified by: DD IPP Rev: D
10.05.28 added route seq DD verf: EC IPP Rev: E 11.06.01
removed qty 1 an310-4 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN310-4 *AN310-4* NUT		Purchased	No			110	Each	98.0000	2				
									**	m 122800 sp.			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST344				98					
				121349				2					
				121827				96					
MS24665-302 *MS24665-302* Cotter Pin		Purchased	No			110	Each	157.0000	1	2			
									**	sp			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST309				157					
				120521				157					
AN310-5 *AN310-5* NUT		Purchased	No			130	Each	30.0000	4				
									**	2x sp 12-10-4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST344				30					
				120124				30					

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

AN3C5A

Purchased

No

130

Each

1,611.000

3

6

**

SP

SP

AN3C5A

Bolt

12

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1604

116419

28

117343

13

117764

7

117872

2

119749

23

120423

28

121255

469

121444

34

121708

500

122141

500

6x

AN44-C12

Purchased

No

130

Each

18.0000

0

2

**

SP

SP

AN44-C12

Eyebolt

Location

Loc Qty

Loc Code

ST362

18

120139

18

2x

AN4C15

Purchased

No

130

Each

42.0000

0

2

**

SP

12-10-4

SP

AN4C15

BOLT

Location

Loc Qty

Loc Code

ST358

42

120124

1

121146

41

2x

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

AN5C11 Purchased No 130 Each 34.0000

AN5C11
BOLT

1 2

**

Location Loc Qty Loc Code

ST337 34

114801 2

120139 32

AN5C15 Purchased No 130 Each 28.0000

AN5C15
BOLT

1 2

**

Location Loc Qty Loc Code

ST338 28

120139 28

AN960C516 Purchased No 130 Each 0.0000

AN960C516

1 2

**

Location Loc Qty Loc Code

ST044 15

82359 15

D3454-3 Manufactured No 130 Each 8.0000

D3454-3
Bushing

2 4

**

Location Loc Qty Loc Code

ST044 8

78193 8

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

D34545 Manufactured No

130 Each

18.0000

2 4

D3454-5

Bushing

Location

Loc Qty

Loc Code

ST044

18

82159

18

Manufactured No

130 Each

35.0000

4 8

D34551

D3455-1

Spacer

Location

Loc Qty

Loc Code

ST044

35

82025

35

Manufactured No

130 Each

50.0000

2 4

D34553

D3455-3

Spacer

Location

Loc Qty

Loc Code

ST044

50

78844

10

83411

40

Manufactured No

130 Each

3.0000

1 2

D3462042

D3462-042

Bracket Assembly

Location

Loc Qty

Loc Code

ST199

3

75182

3

**

**

**

**

4x
1x B.87286 sp.

7x
4

4x
2
B86032 sp
12-10-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

130

Each

1,128.000

3 6

MS21043-3

Nut

**

MD293 SP SP

Location

Loc Qty

Loc Code

FG

72

103691

72

ST301

1056

118077

2

118614

12

118686

30

119758

20

121255

103

121708

889

MS24665-227

Purchased

No

130

Each

106.0000

2 4

MS24665-227

COTTER PIN

**

SP SP

Location

Loc Qty

Loc Code

ST309

106

111041

37

120124

69

NAS1149C0363R

Purchased

No

130

Each

3,005.000

7 14

NAS1149C0363R

Washer

**

SP 12-10-11 SP

Location

Loc Qty

Loc Code

ST297

3005

114742

2805

122063

200

14x

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 86984

86984

Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

NAS1515H5

Purchased

No

130

Each

173.0000

2

NAS1515H5

Washer

Location

Loc Qty

Loc Code

FG

25

103286

5

103691

20

GA

36

120449

36

ST277

112

120299

12

121652

100

D3455-1

Manufactured

No

D3455-1

Spacer

Location

Loc Qty

Loc Code

ST044

35

82025

35

D3443-041

Manufactured

No

D3443-041

Strut Weldment Assembly

Location

Loc Qty

Loc Code

ST199

3

78188

1

78948

2

D3463-042

Manufactured

No

D3463-042

Step Weldment Assembly

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

D3443-9

Manufactured No

110

Each

18.0000

2

4

D3443-9

Pin

**

SP

Location

Loc Qty

Loc Code

ST044

18

78189

1

82161

7

83465

10

AN4C14

Purchased

No

110

Each

40.0000

1

2

AN4C14

BOLT

**

SP

Location

Loc Qty

Loc Code

ST357

40

117688

2

120141

38

MS24665-229

Purchased

No

130

Each

245.0000

2

4

MS24665-229

COTTER PIN

**

SP

Location

Loc Qty

Loc Code

ST309

245

111041

98

118234

147

MS24665-227

Purchased

No

110

Each

106.0000

1

2

MS24665-227

COTTER PIN

**

SP 12-10-4.

Location

Loc Qty

Loc Code

ST309

106

111041

37

120124

69

2x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Parent Item: D412-630-032

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Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

AN4CH3 Purchased No

110

Each

24.0000

2

4

AN4CH3

SS Bolt

**

SP

Location

Loc Qty

Loc Code

ST357

24

117616

1

120139

23

D3465-1

Manufactured No

110

Each

15.0000

1

2

D3465-1

Washer

**

SP

Location

Loc Qty

Loc Code

ST045

15

73449

1

78197

14

AN310-4

Purchased No

130

Each

98.0000

2

AN310-4

8x NUT

**

M/22800 SP SP

Location

Loc Qty

Loc Code

ST344

98

121349

2

121827

96

D3443-043

Manufactured No

110

Each

2.0000

1

2

D3443-043

Strut Weldment Assembly

**

B87159 2x SP

12-10-4.

Location

Loc Qty

Loc Code

ST198A

-8

ST199

10

78954

2

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W/O:		WORK ORDER CHANGES					
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Parent Item: D412-630-032

D412-630-032

Parent Item Name: Pilot/Co-Pilot Step, RH (Folding)

Start Date: 7/6/2012

Required Date: 7/18/2012

Start Qty: 2.00

Required Qty: 2.00

D3454-7

Manufactured No

110

Each

18.0000

2

4

**

SP

D3454-7

Bushing

Location

Loc Qty

Loc Code

ST044

18

82157

18

4X

AN310-7

Purchased

No

110

Each

52.0000

1

2

**

SP 12-10-4.

AN310-7

NUT

Location

Loc Qty

Loc Code

ST344

52

114784

4

119749

8

120124

40

2X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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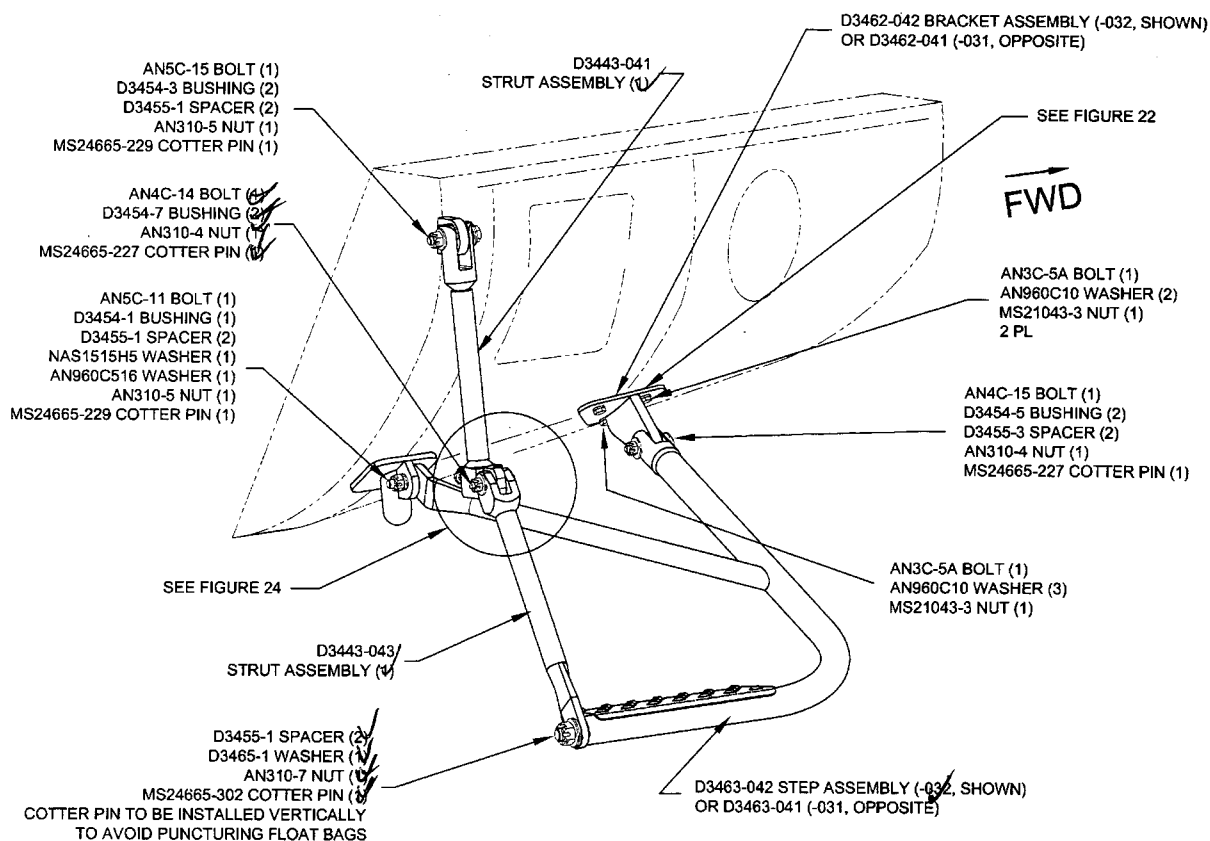


FIGURE 23 – Isometric View D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

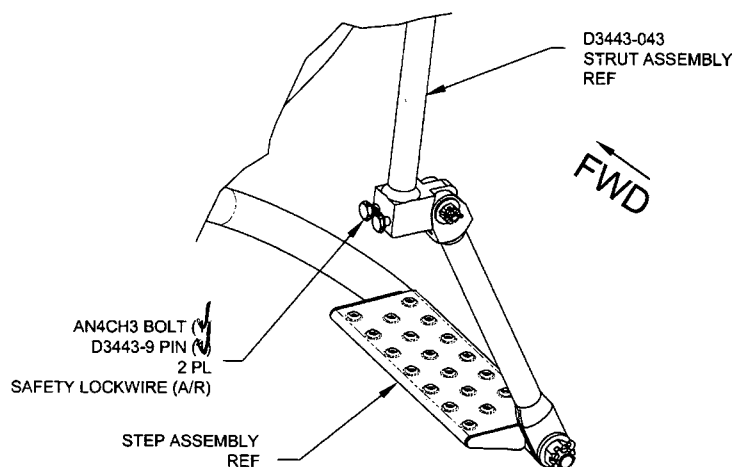


FIGURE 24 – Detail Safety Wiring, D412-630-032 RH, Pilot/Co-Pilot Folding-Step Installation (Shown)
D412-630-031 LH (Opposite)

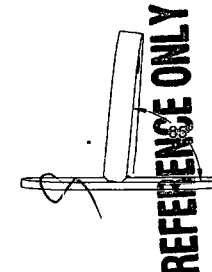
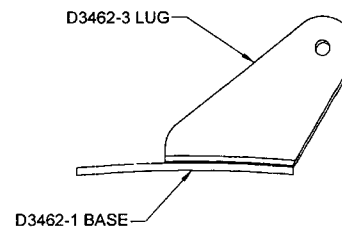
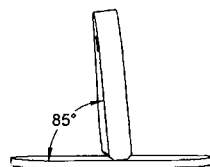
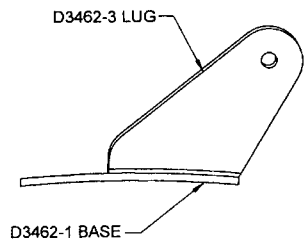
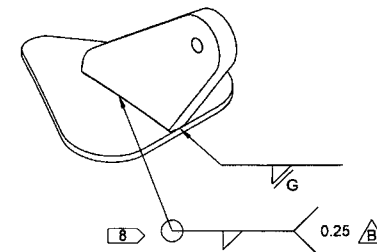
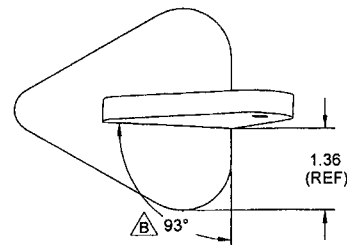
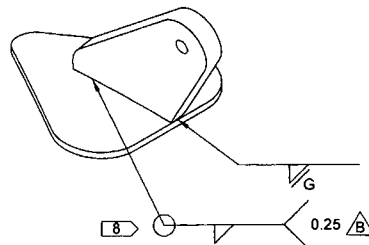
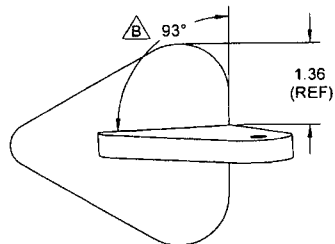
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Revision: M
Date: 08.12.12

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Qty -031	Qty -032	Part Number	Description
X		D412-630-031	PILOT/CO-PILOT STEP, LH (FOLDING)
	X	D412-630-032	PILOT/CO-PILOT STEP, RH (FOLDING)
1	1	D3443-041	STRUT ASSEMBLY
1	1	D3443-043	STRUT ASSEMBLY
2	2	D3443-9	PIN
1	1	D3454-1	BUSHING
2	2	D3454-3	BUSHING
2	2	D3454-5	BUSHING
2	2	D3454-7	BUSHING
6	6	D3455-1	SPACER (2)
2	2	D3455-3	SPACER
1		D3462-041	BRACKET ASSEMBLY
	1	D3462-042	BRACKET ASSEMBLY
1		D3463-041	STEP ASSEMBLY
	1	D3463-042	STEP ASSEMBLY
1	1	D3465-1	WASHER
2	2	AN310-4	NUT (-1)
2	2	AN310-5	NUT
1	1	AN310-7	NUT
3	3	AN3C-5A	BOLT
1	1	AN44-C12	* EYEBOLT
1	1	AN4C14	BOLT
1	1	AN4C15	BOLT
2	2	AN4CH3	BOLT
1	1	AN5C11	BOLT
1	1	AN5C15	BOLT
7	7	AN960C10	WASHER
1	1	AN960C516	WASHER
3	3	MS21043-3	NUT
2	2	MS24665-227	COTTER PIN (-1)
2	2	MS24665-229	COTTER PIN
1	1	MS24665-302	COTTER PIN
1	1	NAS1515H5	WASHER

* USE AN44-C12 EYEBOLT WHEN D412-630-031/-032 IS INSTALLED IN CONJUNCTION WITH D412-630-023/-024/-033/-034TM HELI-ACCESS-STEP



D3462-041 BRACKET ASSEMBLY

D3462-042 BRACKET ASSEMBLY

QTY -041	QTY -042	P/N	DESCRIPTION
X		D3462-041	BRACKET ASSEMBLY
	X	D3462-042	BRACKET ASSEMBLY
1	1	D3462-1	BASE
1	1	D3462-3	LUG

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3462-041" OR "D3462-042" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.75 lbs (TYP)
- 8) WELDING: PER DART QSI 004

C	SHOW VIEWS OF D3462-041 & D3462-042, UPDATE DWG REASON: PRODUCTION FACILITY	DC	07.10.24
B	REVISE DIMENSIONS	RF	05.12.05
A	NEW ISSUE	RF	05.09.20
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.24		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3462 TITLE BRACKET ASSEMBLY SCALE 1:2 REV. C SHEET 1 OF 2 <small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			